

Date: Tuesday, 07/04/2009 10:25:14 AM
 User: Julie Dawson

Process Sheet

Customer : CC-EUR01 Eurocopter France	Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
Job Number : 46999	
Estimate Number : 13560	
P.O. Number :	Part Number : D350591311
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3272 REVB-EUROCOPTR
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 46277	Material :
Written By :	Due Date : 03/05/2009 Qty: 10 Um: Each
Checked & Approved By : JLD 09-04-07	
Comment : Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3272-1 JLM Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for CL 09/04/23

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

S 09/04/24

2.0	D32721	Step
-----	--------	------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: *B46342*

SAD 09-04-09 (10)

3.0	D30671	End Plate
-----	--------	-----------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *346384*

for 09-04-13 10

4.0	D32191	Plate
-----	--------	-------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support *344897*

for 09-04-13 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:25:14 AM
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Job Number: 46999

Part Number: D350591311

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

~~844391~~
M100130
M110431

3-Grind End Plate flush

PH 09.04.14 10

PH 09.04.14 10

SAD 09-04-14 (10)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-15 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/15 (10) L.H.

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 09 04 15

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-15

(10) L.H.

10.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B45395

SAD 09-04-16

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B45398 (17)
B44567 (3)

SAD 09-04-16 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:25:14 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 46999

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet M110731

SAD 09-04-16 (2)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

SAD 09-04-16 10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/04/16 (X10LH)

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate M110130
B46334

PH 09-04-17 10

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M110130

4-Grind End Plate flush

5-Install last rivet as per Dwg.

PH 09-04-17 10
PH 09-04-17 10
PH 09-04-17 10

SAD 09-04-20 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


















Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:25:14 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France		Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH	
Job Number: 46999		Part Number: D350591311	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
17.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION		BE 09/04/20 (10x)	
18.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP		5 09/04/20 (10x)	
19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 touch up alodine		BR 09-04-20 (10x)	
20.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat (White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		M110 939	
START TIME: 10:25		(10x)	
OVEN TEMPERATURE: 320°		BR 09-04-22	
FINISH TIME: 11:00			
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3272 and QSI 005 4.4		M111013 FL 09/04/22 (10x)	
22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: Inspect Powder Coat and Wing Walk		8 09/04/24 (10x)	
23.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
24.0	D22303	Lug	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s) Pick: Packing Kit		(10x)	
Qty Part Number Description Batch		(12) 28	
4 D2230-3 Mounting Lug		45915 46516 9/4/23	
		SQ	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 07/04/2009 10:25:14 AM
User: Julie Dawson

Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 46999

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

B45392

B45914

9/4/23

SP

26.0

D2856400

Abraison Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Abraison Strip

2 x D2856-400-720

46543

9/4/23

SP

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

B44902

9/4/23

SP

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

B45401

9/4/23

SP

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M110467

9/4/23

SP

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

M110731

9/4/23

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 07/04/2009 10:25:14 AM
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Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 46999

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN5-36A

Bolt

M110865

9/4/23

SP

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN960JD10

Washer

M110985

9/4/23

SP

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

16 AN960JD416

Washer

M110363

9/4/23

SP

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M110523

9/4/23

SP

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M110844

9/4/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 46999

Part Number: D350591311

Job Number:



Seq. #: Machine Or Operation: Description :

36.0 MS21042L4 Nut

Handwritten: S (circled)



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

Handwritten: M110450

Handwritten: 9/4/23

Handwritten: 50

37.0 MS21042L5 Nut

Handwritten: S (circled)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

Handwritten: M109840

Handwritten: 9/4/23

Handwritten: 50

38.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten: S 09/04/24 (X1044)

39.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: *Handwritten: D*

Handwritten: 9/4/24 (10)

40.0 QC21 FINAL INSPECTION/W/O RELEASE



Handwritten: 09/04/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Handwritten: MF 09-04-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

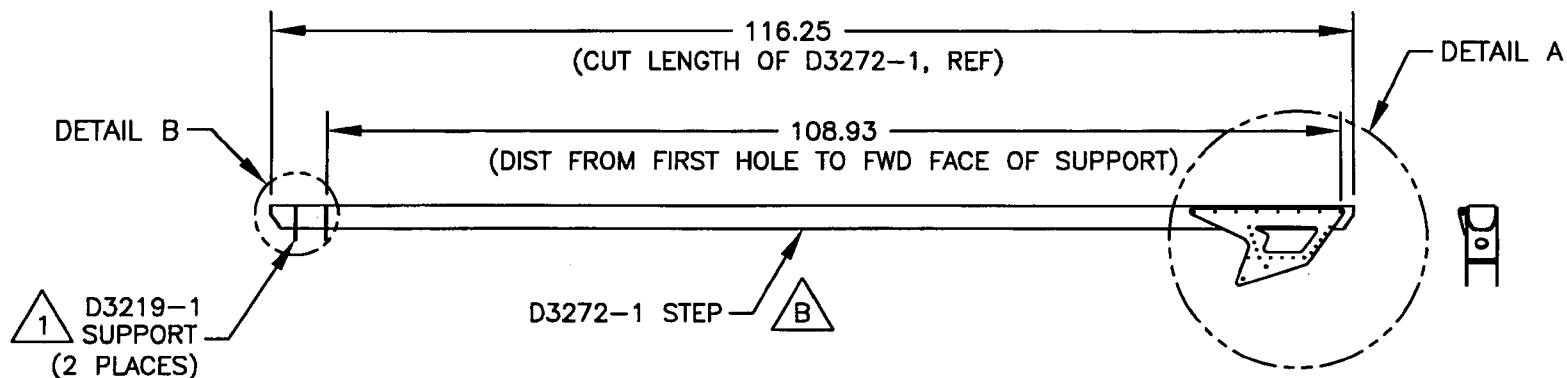
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. *46999*

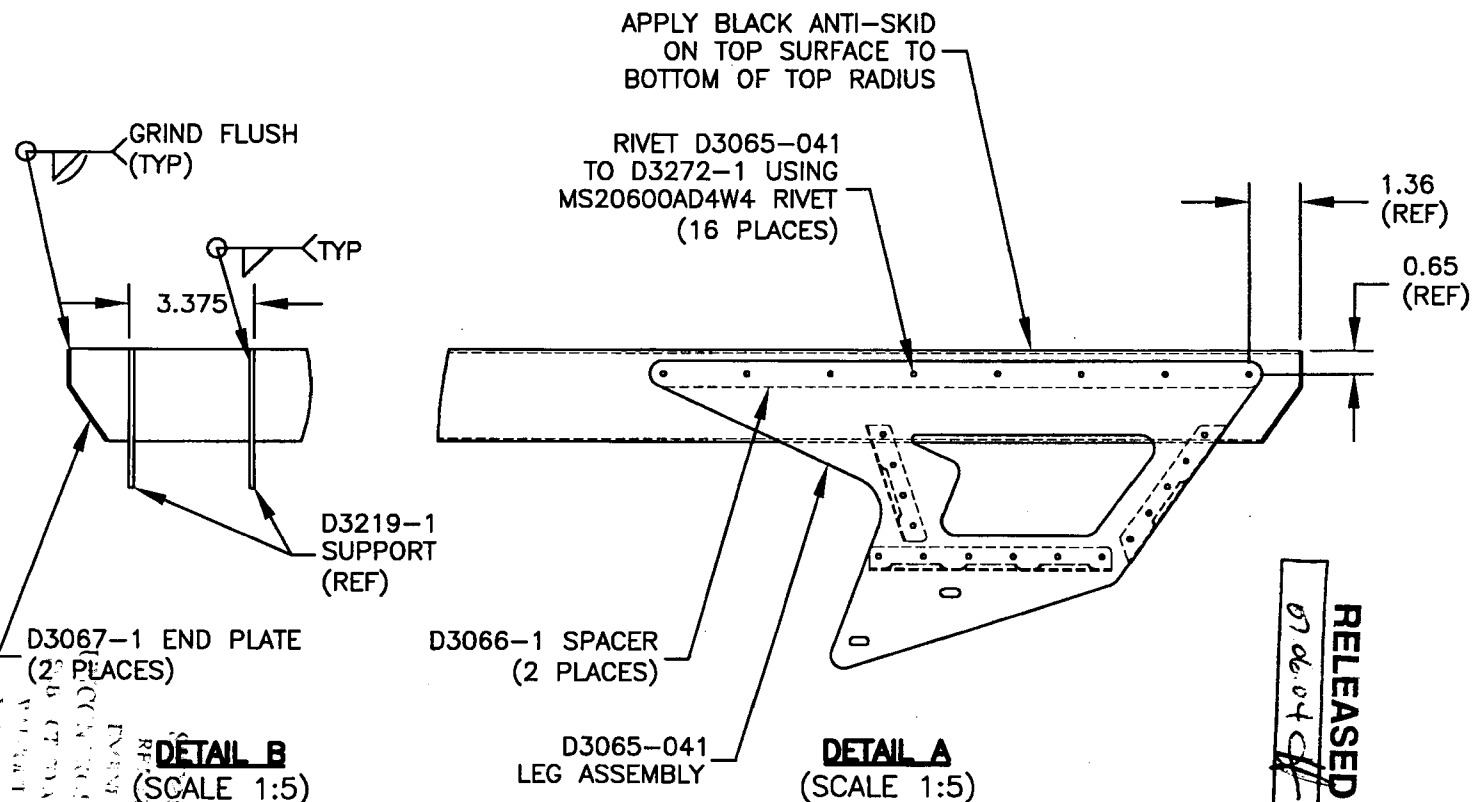
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DART



D3272-041 STEP ASSEMBLY (LH, SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07 Dec 04

DESIGN	qo	UNKNOWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	ce	APPROVED	DRAWING NO.	REV. B
			D3272	SHEET 2 OF 3
DATE			TITLE	SCALE
07.05.18			STEP ASSEMBLY, HI LONG	1:20

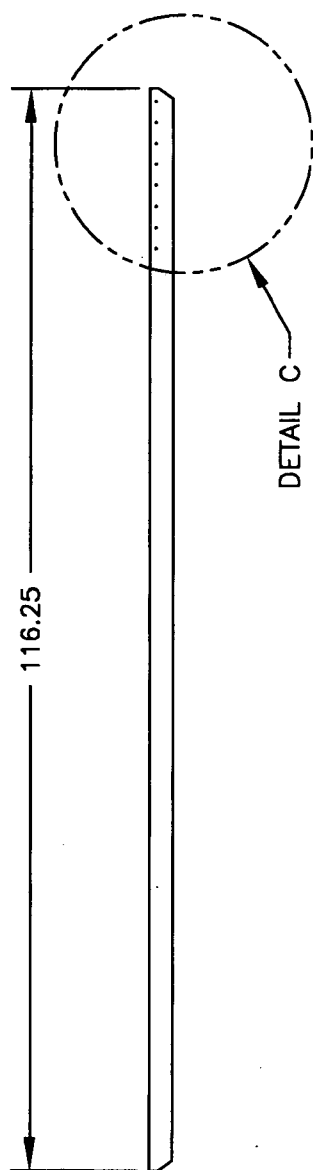
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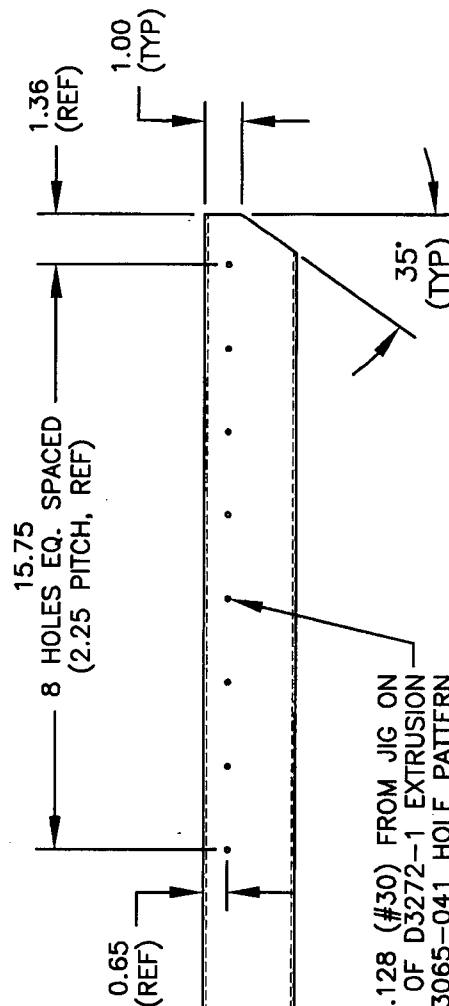
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DESIGN 9P	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK COPY
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